

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006884**Date Inspected:** 24-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG crossbeams**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG segment 1AAW

This QA assisted Caltrans QA Mr. Erik Prue perform Visual Testing (VT) of material and welds after the contractor sandblasted this segment. This QA observed numerous areas of undercut, overlap, porosity and incomplete fusion. All the areas were marked for repair and ZPMC QC indentified as Mr. Shen Xuejun and ABF inspector Mr. Man Kit Li were informed of the non compliant welds by Caltrans QA Mr. Prue.

OBG segment 1AAE

This QA assisted Caltrans QA Mr. Harianch perform Visual Testing (VT) of material and welds after the contractor completed and accepted the VT of this segment. This QA observed several areas of undercut. All the areas were marked for repair and ZPMC QC indentified as Mr. Shen Xuejun was informed of the non compliant welds by Caltrans QA Mr. Harianch.

OBG cross beam CB1 (in superstructure trial assembly)

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This QA observed that the contractors personnel appear to be in the process of aligning this crossbeam with the east and west lines. No other significant work was observed on this CB during the time this QA was present.

OBG cross beam CB2 (in superstructure trial assembly)

This QA observed ZPMC personnel installing side panel stiffener splice plates. No other significant work was observed on this CB during the time this QA was present.

OBG cross beam CB3 (in superstructure trial assembly)

This QA observed ZPMC personnel match drilling bolt holes on the deck panel at the splice joint to the west line using the splice plates as a template. No other significant work was observed on this crossbeam during the time QA was present.

OBG cross beam CB4

This QA performed Visual Testing (VT) of material and welds after the contractor sandblasted the outside surfaces of this crossbeam. This QA observed one area of porosity on the west side panel where a temporary weld was removed. This area was marked for repair and recorded on the weld repair tracking log for this crossbeam.

NOTE: The upper half of the east and west side panels were inaccessible for VT.

OBG cross beam CB5

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

OBG cross beam CB6

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

OBG cross beam CB7

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

OBG cross beam CB8

This QA observed that the contractor is fitting and tack welding the intermediate panel to the deck panel. No other significant work was observed on this crossbeam during the time QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

As mentioned above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
